

Work Order ID 73309

Wednesday, August 31, 2011 10:47:48 AM



Page 1

Item ID: D2877

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/1/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-09-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2877

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-deburr

6061-125

B 11-9-15



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-9-15

120

QC8- Inspect parts - second check

0.00



QC

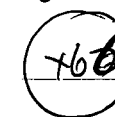
Memo

0.00

Quality Control

Sulalis

count



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Saddle Spacer

Start Date: 9/1/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 30.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
	<i>u / AS</i>								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

66x PM-L 11/04/15

66 BR 11-9-15.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Accept



Setup Start



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Stop



Item Name: Saddle Spacer

Start Date: 9/1/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 025

0.00



Packaging

Memo

0.00

Packaging

8/31/11 (66)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8/31/11 (66)

8/31/11 (66)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 31, 2011 10:47:45 AM

Page 1

Work Order ID: 73309

Parent Item: D2877

Parent Item Name: Saddle Spacer




Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP B 00.05.19 Added inspect level 8 EC
IPP C 06.04.26 Water jet EC
IPP Rev:D Now M6061-T6 06-06-23 JLM
IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			110	sf	131.1700	0.0607	1.916842	4,		
6061-T6 .125 Sheet											11-9-15		

Location

Loc Qty

Loc Code

MAT021

131.17

113608

77.17

118217

54

118217

62

W/O:		WORK ORDER CHANGES					
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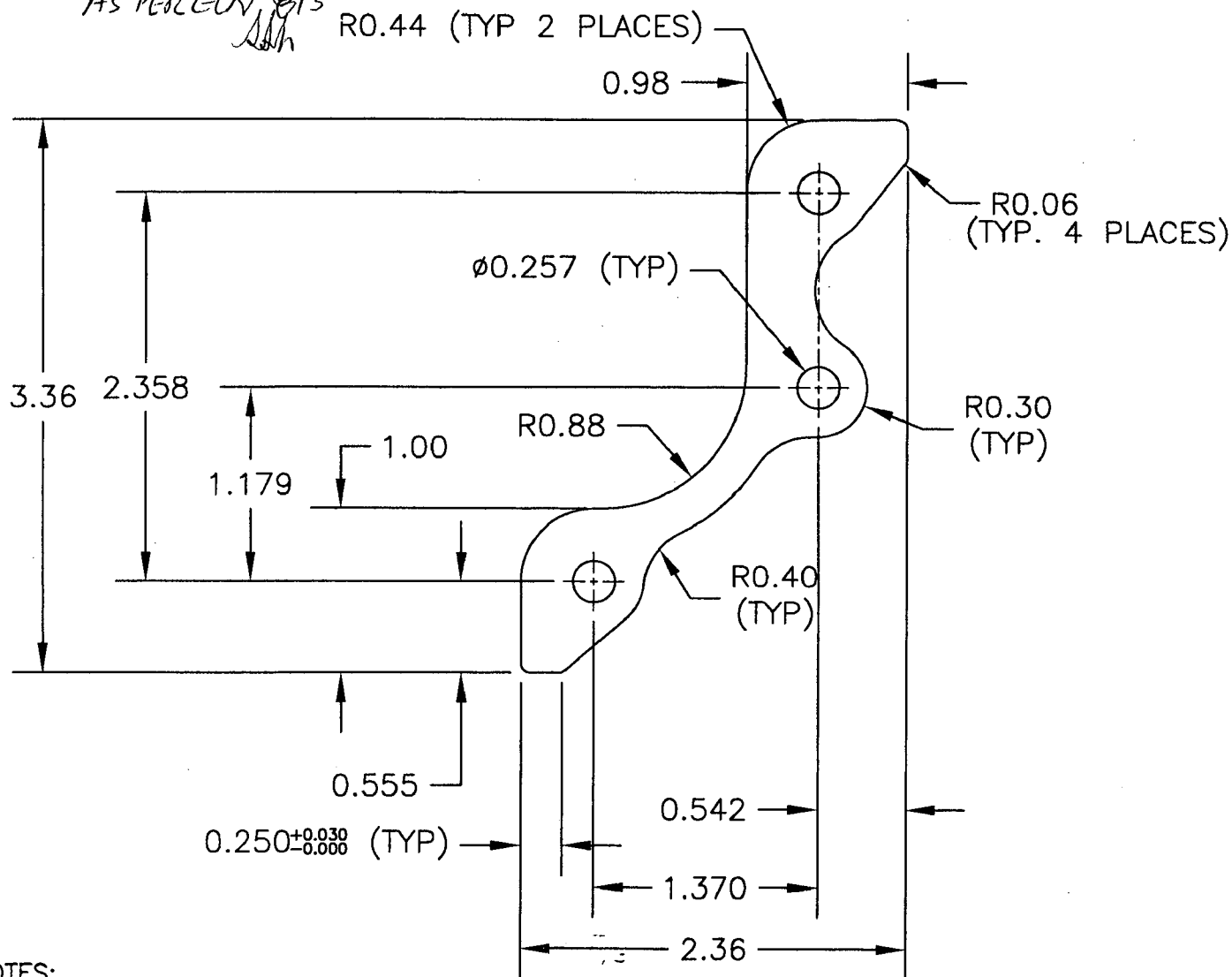
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
*06.06.21**AS PER ECN 813***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK (REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK (REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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